



007303

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Canada

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RBW6305G19631-3G
Job Sheet 187745



Part No: RBW6305G19631-3G

Job Qty: 1 ea

Part Name: Main Rotor Drive Tool 1 (Box 1 Of 2)



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 12/13/18

Job Tracking No:

Due Date: 2/15/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RBW6305G19631-3G Rev 3 IPP Rev A 18.03.19 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		2/15/19	0.00	0.00	Start Up Small Fab-4		MLL
110	Small Fab	1 pcs		2/15/19	0.00	1.00	Small Fab-4		MLL DAS
120	QC	1 pcs		2/15/19	0.00	0.00	QC5		38
130	Packaging	1 pcs		2/15/19	0.00	0.00	Packaging3-1		DAS 2-89
140	QC21-FG	1 Ea		2/15/19	0.00	0.00	QC21		28

Part Op 110 - 1-Engrave placard RB41011 using marktronic engraver 2-Transfer drill Dart placard RB41011 into Pelican case
Descriptions: APP-1650-E 3-Deburr holes and remove chips from case. 4-Rivet Dart placard to Pelican case 5-Glue placard
RBW6305G19631-3G-23 and RBW6305G19631-3G-25 to RBW6305G19631-3G-21 foam as per DWG. 6-Glue foam to
case and pack case as per DWG.

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
RB41011	Dart Tooling Placard, Aluminum	1 Ea (1 ea)	90-Start up Operation	5021040
97524A032	Sealing Blind Rivet	4 Ea (4 ea)	110-Small Fab	5113449
APP-1650-E	Case	1 Ea (1 ea)	110-Small Fab	5133011
RBW6305G13231-3G	Gimball Carbon Seal Installer	1 Ea (1 ea)	110-Small Fab	5067425
RBW6305G13731-3G	Gimball Carbon Seal Remover	1 Ea (1 ea)	110-Small Fab	5065876
RBW6305G14031-3G	Gimball Carbon Seal Remover	1 Ea (1 ea)	110-Small Fab	5067409
RBW6305G14331-3G	Upper Module Lip Seal Installer	1 Ea (1 ea)	110-Small Fab	5067419
RBW6305G17131-3G	Drive Quill Seal Housing Removal Tool	1 Ea (1 ea)	110-Small Fab	5065471
RBW6305G17631-3G	Tool Pump 1-2-3 Drive Quill Lip Seal Remover	1 Ea (1 ea)	110-Small Fab	5065874
RBW6305G17931-3G	Tool Pump 1-2-3 Drive Quill Lip Seal Installer	1 Ea (1 ea)	110-Small Fab	5061200
RBW6305G18251-3G	Guide Pumps/Ecs Drive Quill Seal Housing Installer	1 Ea (1 ea)	110-Small Fab	5064779
RBW6305G19631-3G-19	Bottom Foam use in case APP-1650-E	1 Ea (1 ea)	110-Small Fab	5133014
RBW6305G19631-3G-21	Top Foam use in case APP-1650-E	1 Ea (1 ea)	110-Small Fab	5133013
RBW6305G19631-3G-23	Inside Placard	1 Ea (1 ea)	110-Small Fab	5061835
RBW6305G19631-3G-25	Tool Layout Placard	1 Ea (1 ea)	110-Small Fab	5066926

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	RB41011	1	668	0
110-Small Fab	97524A032	4	587	0
	APP-1650-E	1	3	0

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QS1042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

RBW6305G13231-3G	1	2	0
RBW6305G13731-3G	1	2	0
RBW6305G14031-3G	1	2	0
RBW6305G14331-3G	1	2	0
RBW6305G17131-3G	1	2	0
RBW6305G17631-3G	1	2	0
RBW6305G17931-3G	1	2	0
RBW6305G18251-3G	1	2	0
RBW6305G19631-3G-19	1	2	0
RBW6305G19631-3G-21	1	2	0
RBW6305G19631-3G-23	1	1	0
RBW6305G19631-3G-25	1	3	0

Part Specifications

Specifications could not be found.

Plex 12/13/18 11:42 AM Dart.lajeunesse.marie



Container No: S141697



Part: RBW6305G19631-3G

Job No: 187745

Serial No/Batch: S141697

Revision: 3

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 01/03/19

Entered: _____ Date: _____



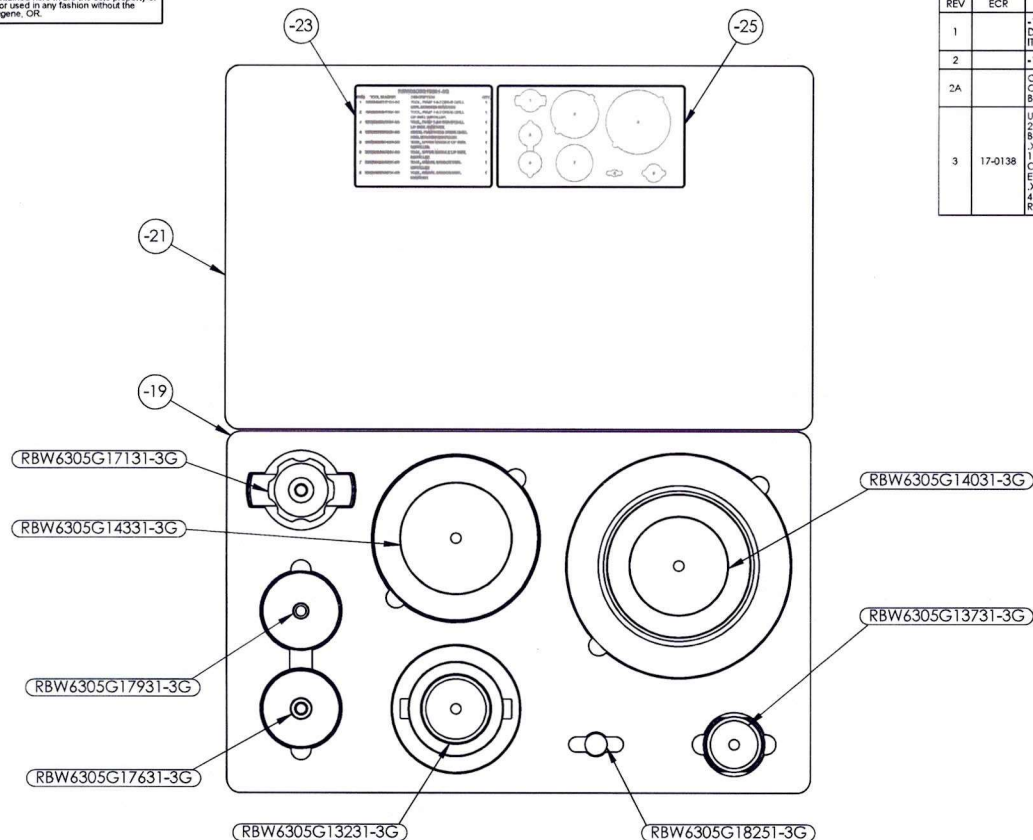
WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

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REVISIONS						
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED	
		-19 CHD FOAM DIMENSIONS, ADDED FINGER HOLES Ø3.164 CUTOFF PER R.W. CHD -21 FOAM DIMENSIONS, CHD CUTOFF TO RECESS FOR -23 & -25 PER R.W. ADDED MISSING TOOL NUMBER & ITEM NUMBERS TO -23 PER R.W.	3/29/2011	RJC	RW	
2		-19 CHD FOAM CUTOFF DEPTH DIMENSIONS SO TOOLS ARE SUB-FLUSH.	2/6/2013	BIM	SE	
2A		CHD TITLE WAS MAIN ROTOR DRIVE SEAL REPLACEMENT TOOL KIT IS MAIN ROTOR DRIVE TOOL KIT 1. CHD BOM DESCRIPTIONS -1 THRU -15 TO MATCH PARTS MANUAL. -23 CHD DESCRIPTIONS, WAS BUYOUT IS MANUFACTURED. CHD -25 WAS B/O IS MANUFACTURED.	10/30/2013	CFS	RJC	
3	17-0138	UPDATED TO NEW DRAFTING STANDARD. -1 THRU -15 DELETED DASH NUMBERS. -19 CHD DIMS WAS 2.80 IS 3.00, WAS 50° IS 45°, ADDED DIM 2.00, DELETED DIMS 1.40, 1.0". CHD B/O INFO WAS Y20 BLACK L.R. SPECILATY IS ETHAFOAM 220 BLACK CASE SOLUTIONS. CHD TOLERANCE WAS .XXX ±.005 .XX ±.01 IS .XXX ±.010 XX ±.03. -21 CHD DIMS WAS 29.12 IS 29.19, WAS 18.09 IS 18.10, WAS 1.80 IS 1.77, WAS .06 IS 2X .05. ADDED DIMS 4X 45°, 2X 1.00, 2X 2.75, 1.37, 8X R.16. SIMPLIFIED CUTOFF ON BACK OF FOAM. DELETED DIM 4X 2". CHD B/O INFO WAS C200 FLAT BLACK L.R. SPECILATY IS ETHAFOAM 220 BLACK CASE SOLUTIONS. -21, -23, -25 CHD TOLERANCE WAS .XXX ±.005 .XX ±.01 IS .XXX ±.010 XX ±.03. -23, -25 ADDED USE PDF NOTE. -23 CHD DIM WAS 5.50 IS 5.00, WAS R.37 (X4) IS 4X R.13, DELETED TEXT ARIAL, 3/16 LETTERS (X4), ARIAL, 1/8 LETTERS. -25 CHD DIM WAS R.37 (X4) IS 4X R.13, WAS 5.50 IS 5.00, DELETED TEXT ARIAL, 1/8 LETTERS.	6/13/2017	RJC	JAG	

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SUBJECT TO AMENDMENT
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WORK ORDER
NO. 187745 MCS
1810-13

NOTE:

1. REFERENCE AGUSTA T/N 3G6305G19631.
2. ALSO SOLD WITH KIT RBW6305G01531-3G.

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
			1		TOOL, PUMP 1-2-3 DRIVE GUILLS SEAL HOUSING REMOVAL		RBW6305G17131-3G	1
			1		TOOL, PUMP 1-2-3 DRIVE GUILLS LIP SEAL INSTALLER		RBW6305G17931-3G	1
			1		TOOL, PUMP 1-2-3 DRIVE GUILLS LIP SEAL REMOVER		RBW6305G17631-3G	1
			1		GUIDE, PUMPS/ECS DRIVE GUILLS SEAL HOUSING INSTALLER	6061	RBW6305G18251-3G	1
			1		TOOL, UPPER MODULE LIP SEAL INSTALLER		RBW6305G14331-3G	1
			1		TOOL, UPPER MODULE LIP SEAL INSTALLER		RBW6305G14031-3G	1
			1		TOOL, GIMBAL CARBON SEAL INSTALLER		RBW6305G13231-3G	1
			1		TOOL, GIMBAL CARBON SEAL REMOVER		RBW6305G13731-3G	1
	B/O	-17	1		CASE	PLASTIC	PELICAN CASE # APP-1650-E	N/S
	B/O	-19	1		BOTTOM FOAM	ETHAFOAM 220, BLACK	8.71 X 17.97 X 29.12 (CASE SOLUTIONS)	2
	B/O	-21	1		TOP FOAM	ETHAFOAM 220, BLACK	1.77 X 18.10 X 29.19 (CASE SOLUTIONS)	3
		-23	1		INSIDE PLACARD	PLASTIC		4
		-25	1		TOOL LAYOUT PLACARD	PLASTIC		5
	B/O		1		DART PLACARD	ALUMINUM	RB41011	N/S

DART AEROSPACE	
TITLE MAIN ROTOR DRIVE TOOL KIT 1	
DWG NO.	RBW6305G19631-3G
REV	3
MAT'L	UNLESS OTHERWISE SPECIFIED
FEAT	DIMENSIONS ARE IN INCHES
FINISH	.XXX ± .005 FRACTIONS ± 1/8
	.XX ± .01 ANGLES ± 5°
	.X ± .1 SURFACES ± 125
SPEC	1. BREAK ALL SHARP EDGES
	.015 X 45° OR .015R
DRAWN BY:	CLOUGH
CHECKED:	DD 06/14/2017
OPPS APPR:	AA 06/14/2017
QA APPR:	JL 06/28/2017
APPROVED:	JAG 07/07/2017
SCALE	1:6
DATE	2/7/2011
SHEET	1 OF 5